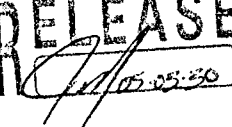


5/24

DART AEROSPACE LTD	Work Order:	23435
Description: Bracket Assembly	Part Number:	D2804-041
Dwg: D2804 Rev. B	Qty:	10
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler Dwg not required	JJ	05.05.26	10																				
2	GA	Press D2805-1 into arm as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D2804-1</td><td>Bracket</td><td>B23622</td></tr><tr><td>1</td><td>D2805-1</td><td>Stop</td><td>D23628</td></tr><tr><td>1</td><td>D2809</td><td>Bushing</td><td>D22529</td></tr></table>	Qty	Part Number	Description	Batch	1	D2804-1	Bracket	B23622	1	D2805-1	Stop	D23628	1	D2809	Bushing	D22529	SAD	05/08/31	10				
Qty	Part Number	Description	Batch																						
1	D2804-1	Bracket	B23622																						
1	D2805-1	Stop	D23628																						
1	D2809	Bushing	D22529																						
3	QC5	Inspect work to Step 2	J	05.05.11	10																				
4	FP	Powder Coat Gloss White (Ref: 4.3.5.1) as per QSI 005 4.3	FC	05 09 22	10																				
5	QC3	Inspect Powder Coat	ML	05 09 12	10																				
6	GA	Press D2809 into arm as per Dwg D2804	SB	05/09/22	10																				
7	GA	Spray LPS-3 on Bolt Shaft, not on thread as per Dwg D2804 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>2</td><td>AN3C16A</td><td>Bolt</td><td>M17185</td></tr><tr><td>2</td><td>MS21043-3</td><td>Nut</td><td>M17239</td></tr><tr><td>4</td><td>NAS1515H3</td><td>Washer</td><td>M17944</td></tr><tr><td>A/R</td><td>LPS-3</td><td>Corrosion Spray</td><td>M17395</td></tr></table>	Qty	Part Number	Description	Batch	2	AN3C16A	Bolt	M17185	2	MS21043-3	Nut	M17239	4	NAS1515H3	Washer	M17944	A/R	LPS-3	Corrosion Spray	M17395	SB	05/09/22	10
Qty	Part Number	Description	Batch																						
2	AN3C16A	Bolt	M17185																						
2	MS21043-3	Nut	M17239																						
4	NAS1515H3	Washer	M17944																						
A/R	LPS-3	Corrosion Spray	M17395																						
8	GA	Assemble as per Dwg D2804.	SB	05/09/22	10																				
9	QC5	Inspect work to Step 8	J	05.09.28	10																				
10	ST	Identify and Stock	CZ	05/10/05	10																				
11	AC	Cost / part: 64.02	SAC	05.10.06	10																				
12	DC	Close W/O 47.87 Inspect Level 21	L7	05/10/06	10																				

Rev	Date	Change	Revised By	Approved
A	00.11.09	New Issue	EC	
B	00.11.15	Revise pick list	EC	
C	01.03.02	Added D2809 to pick list	EC	
D	01.04.26	Reformat	EC	
E	05.02.22	Revised Step 7	KJ/JLM	
F	05.03.30	MS21043-3 was MS21042L3	KJ/JLM	

RELEASED

 05.05.26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: DP Date: 05/10/06

NOTE: Date & initial all entries

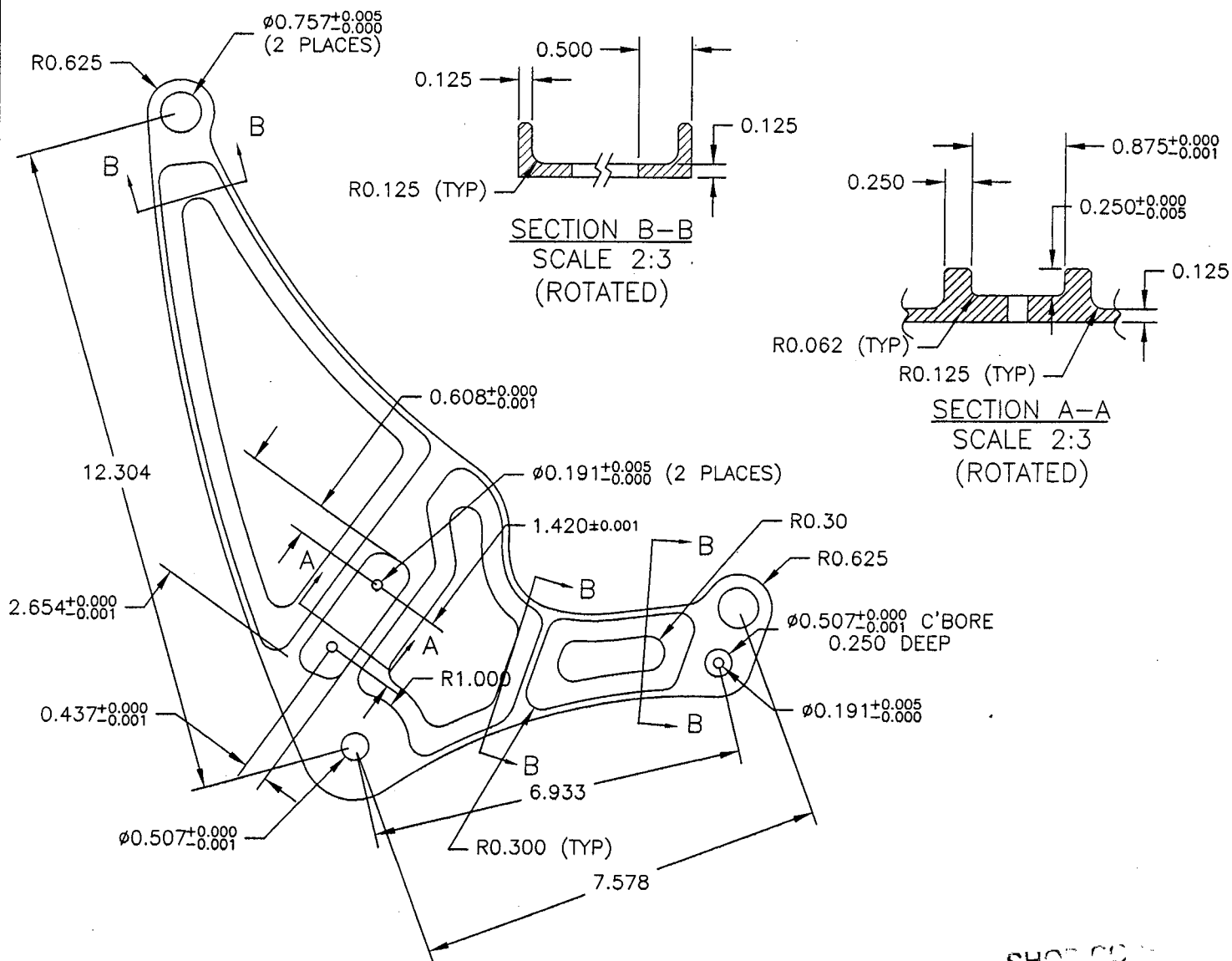
QA: N/C Closed: _____ Date: _____



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 1 OF 2
DATE 04.11.22	TITLE STA 155 BRACKET		SCALE 1:3
A	00.11.07	NEW ISSUE	
B	04.11.22	ADD CUTOUTS & -043/-044	

RELEASED

05.03.11



D2804-1 BRACKET (SHOWN). D2804-2 BRACKET (OPPOSITE)

- 1) MACHINE PER DRAWING FILE "D2804.SLDPR1"
- 2) MATERIAL: 6061-T6 (QQ-A-200/8) OR (QQ-A-250/11) 0.500 THICK
- 3) DEBURR TO LEAVE R0.030 - 0.063 ON ALL EDGES
- 4) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
DATE 10
ENGINEER

UNSCHEMATIC
S

NO. 23435

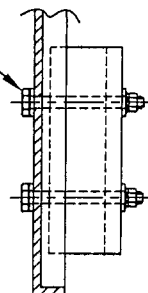
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DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2804	REV. B SHEET 2 OF 2
DATE 04.11.22		TITLE STA 155 BRACKET	SCALE 1:3

AN3C16A BOLT (1)
NAS1515H3 WASHER (2)
MS21043-3 NUT (1)
INSTALL BOLT WITH LPS-3 CORROSION
INHIBITOR (ENSURE NO LPS-3 ON THREADS)
(2 PLACES)



SECTION C-C
SCALE 1:3
(ROTATED)

USE D2804-1 FOR D2804-041/-043
USE D2804-2 FOR D2804-042/-044

USE D2805-1 FOR D2804-041
USE D2805-2 FOR D2804-042
USE D2805-3 FOR D2804-043
USE D2805-4 FOR D2804-044
PRESS INTO PLACE PRIOR TO POWDER COAT

PRESS D2809 INTO PLACE PRIOR TO
POWDER COAT

SHOP COPY
RETURN TO
ENGINEERING

UNCONTROLLED
RELEASED

05-03-11 *[Signature]*

WORK C.

NO. 23435

D2804-041/-043 BRACKET ASS'Y (SHOWN).
D2804-042/-044 BRACKET ASS'Y (OPPOSITE)

6) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.1) OR GREY SANDTEX (4.3.5.6)
OR BLACK SANDTEX (4.3.5.7) OR GREEN SANDTEX (4.3.5.8) PER DART QSI 005 4.3

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 25, 2005
03:44 pm

Work Order No : 0023435
Project Name : D2804-041
Project For : WK524
Work Order Type : Main
Main WO Number :
House Part Number : D2804-041
Description : Bracket Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-25-05
Est Finish Date : 06-16-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00